XP 002043474

1/1 - (C) WPI / DERWENT
AN - 80-L3029C ç47!
PR - SU78 643046 780710
TI - Completely rolled wheel mfr. - with constant forced cooling of disc surface on internal side during rolling
IW - COMPLETE ROLL WHEEL MANUFACTURE CONSTANT FORCE COOLING DISC SURFACE INTERNAL SIDE ROLL
IN - BLAZHNOV G A; KRASHEVICH V N; UZLOV I G
PA - (DNFE-R) DNEPR FERR METAL
PN - SU727287 A 800425 DW8047 000pp
ORD - 1980-04-25
IC - B21H1/04
FS - GMPI
DC - P52
AB - SU-727287 The method involves rolling the discs and rim of the forged blank at 1050-1150 deg.C and subsequent bending of the disc and sizing of the rim. To increase the homogeneity of structure along the disc section and the accuracy of the geometrical parameters of the wheel, the internal side of the disc surface is subjected to constant forced cooling to a depth of 0.2-0.25 of its thickness, down to 650-720 deg.C. or example, in manufacturing a steel wheel of dia. 850 mm, the blank (1), at 1080 deg.C, is fed to the wheel rolling mill, and the part (3) of the disc which is to be rolled is sprayed with cooling water from jet (5) at a pressure of 6 atm. for 20 s, after which the disc is bent on a press of force 3500 tons, and the rim is sized. A wheel made in this way has a uniform structure along the cross section and length and shows very little buckling.